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## (54) PROCESS AND APPARATUS FOR PRODUCING LIGHT OLEFINS

VERFAHREN UND VORRICHTUNG ZUR HERSTELLUNG VON LEICHTEN OLEFINEN

PROCEDE ET APPAREIL PERMETTANT DE PRODUIRE DES OLEFINES LEGERES

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**Description****BACKGROUND OF THE INVENTION****5    Field of the Invention**

[0001] The present invention relates to the production of light olefins. In particular, the invention relates to a process in accordance with the preamble of claim 1 for producing light olefins, such as propylene, butylenes and amylanes, from hydrocarbon feedstocks comprising, e.g. light, heavy and vacuum gas oils, naphta, propane, butanes or light condensates. The invention also relates to an apparatus in accordance with the preamble of claim 17 suited for the production of light olefins from said hydrocarbon feedstocks.

**Description of Related Art**

15 [0002] Several commercially utilized methods are currently known for the production of propylene, butylenes or amylanes from various petroleum-based hydrocarbon feedstocks. These methods include steam cracking, fluidized bed catalytic cracking and dehydrogenation. The prior art methods suffer from certain disadvantages indicated as follows:

[0003] Steam cracking: The main product of the steam cracking process is ethylene. Propylene and heavier olefins are the most important by-products and their yields cannot substantially be increased by a change of operating conditions.

20 Other by-products are comprised of fuel gas, aromatic tar and coke, which are harmful to the process and will have low or no value.

[0004] Conventional fluidized bed catalytic cracking (FCC): The yield of light olefins is low and the quality of the main product component, FCC gasoline, is poor for future requirements due to its low octane number and high content of benzene and heavy olefins. To increase the formation of light olefins, higher temperatures and short residence times are needed, which are not practical in the present reactors, as will be described below. When the temperature is raised, the reaction becomes more endothermic and the temperature difference between the reactor and the regenerator decreases because the regenerator temperature cannot be raised without damaging the catalyst. For the supply of all the energy needed, either the catalyst-to-oil ratio must be increased or a part of energy must be transferred in some other way.

30 [0005] Catalytic dehydrogenation: Hydrogenation of hydrocarbons takes place at relatively high temperatures. The dehydrogenation reaction is highly endothermic requiring high, carefully controlled heat input to the reaction zone. This has resulted in complicated, expensive reactor/regenerator designs.

[0006] The reactor types which have been used in hydrocarbon conversion processes can be classified as follows:

- 35    1. Fixed bed reactors and  
      2. Fluidized bed reactors.

[0007] At very high fluidizing velocities, the bed surface is no longer sharply defined but replaced by a zone, where the solids content slowly decreases with the height. If particles are fine, this leads to fast fluidization where the solids entrainment occurs at such high rates that, in general, fast fluidized beds can only be maintained by recirculation of the entrained solids via cyclones. This kind of system is called circulating fluidized bed, CFB.

[0008] One of the most widely used reactor system is the FCC system, the main components of which are the riser operating in the fast fluidized flow region, the high volume reactor, operating in the dilute suspension phase, and the regenerator, operating in the fluidized bed region. This kind of reactor system has typically a high riser (30 - 40 m) compared to the regenerator, which makes it possible to connect the regenerator to the riser-reactor combination at a point located between the reactor upper part and the riser lower part. The riser must be clearly higher than the regenerator to ensure the hydrodynamic viability of the system. This sets limiting conditions for the process caused by residence time and equipment design. These limiting conditions are particularly unfavourable, when short residence times and high solids concentrations are needed in the reactor. This sets limits regarding residence time and solids concentrations - very short residence times or high solids concentrations cannot be achieved with a FCC system.

[0009] US Patent Specification No. 4 980 053 describes trials made by using heavy hydrocarbon fractions, such as vacuum gas oil, as feed, under more severe operating conditions than FCC and milder than those of steam cracking, which results in a higher yield of propylene and butylenes than ethylene. This process, known as the Deep Catalytic Cracking process (DCC), has been studied in pilot units and in a commercial, revamped FCC unit. The unit is practically a FCC unit, with different operating parameters and a modified catalyst.

[0010] A process for converting saturated hydrocarbons to light olefins, in particular propylene, by using a zeolite catalyst and reaction temperatures in the range of 500 to 700 °C with low hydrocarbon partial pressures, is disclosed in EP Patent Application No. 395 345. In the examples of the said reference, the process has been implemented using

fixed bed reactors, which makes it possible to keep the residence times short. The process can, however, also be carried out in fluidized bed systems. The prior art process is claimed to have lower capital costs and to be more selective for propylene and butylenes than conventional steam cracking.

[0011] However, the above mentioned reactor systems have serious limitations restricting their utilization particularly in processes, wherein short residence times and high solids concentrations in the reactor are required. In such a process, the riser should be low compared to the regenerator. The problem is even worse if, at the same time, there is a large pressure difference between the regenerator and the riser. In that situation the regenerator cannot be connected to the riser cyclone. Instead, complicated systems to circulate the catalyst are needed. In practice the reactor riser would have to be designed unpractically high, and in that case the gas velocity would grow too high and the catalyst volume fraction in the riser would be too low for optimum process conditions. The FCC system has the limitation that the catalyst volume fraction cannot be freely controlled without affecting other process variables.

### Summary of the Invention

[0012] It is, therefore, an object of the present invention to overcome the above-mentioned deficiencies of the prior art and to provide a novel process and reactor system for preparing light olefins from a hydrocarbon feedstock.

[0013] The invention is based on the concept of carrying out the catalytic conversion of the hydrocarbon feedstock in a circulating fluidized bed (CFB) reactor using short residence times. Preferably, the spent catalyst is also regenerated in a circulating fluidized bed (CFB) regenerator and all the thermal energy needed for the endothermic conversion reaction is supplied by the recycled regenerated catalyst particles.

[0014] More specifically, the process according to the invention is characterized by what is stated in the characterizing part of claim 1.

[0015] The reactor system according to the invention comprises at least one circulating fluidized bed unit (reactor) for catalytic conversion of hydrocarbons, provided with feed nozzles for the hydrocarbon feedstock and for the recycled catalyst particles. The CFB reactor is also provided with a cyclone or similar separator for separating the spent catalyst from the product stream, said cyclone having a product outlet for the light olefins and a solids outlet for the separated catalyst particles. Furthermore, the reactor system comprises at least one circulating fluidized bed unit for catalyst regeneration by combustion, provided with feed nozzles for the spent catalyst to be regenerated and a cyclone or similar separator for separating the regenerated catalyst from the flue gases of the combustion process. The feed nozzle of the regenerator unit is connected to the solids outlet of the cyclone of the reactor unit.

[0016] More specifically, the reactor system is mainly characterized by what is stated in the characterizing part of claim 17.

### Brief Description of the Drawing

[0017] The attached drawing shows, in schematic fashion, a simplified process scheme for a preferred embodiment of the invention.

### Detailed Description of the Invention

#### Definitions

[0018] Within the scope of the present invention, the terms "spent catalyst" and "deactivated catalyst" are interchangeably used to designate catalyst particles deposited with coke or other impurities, which lower the catalytic activity of the catalyst.

[0019] The abbreviation "CFB" is used to denote a "circulating fluidized bed", in which solids are transported vertically in a vertical pipe by a high-velocity gas stream. The CFB is preferably equipped with a cyclone, in which solids are separated from gas flow. Often there is also a return pipe connected to the cyclone for recycling of the solids. Such a return pipe represents a preferred embodiment of a CFB according to the invention, but the CFB units described below are also operable without return pipes. The superficial gas velocities in the CFB reactor are typically in the range of about 2 to about 10 m/s. The throughput of the solids (catalysts particles) is very large at these gas velocities which minimizes the required reactor diameter. The superficial gas velocity in the CFB regenerator is not critical, because the catalyst can be recycled to achieve the desired residence time for catalyst regeneration.

[0020] "Light olefins" mean olefins comprising 1 to 6 carbon atoms, preferably ethylene, propylene, butylenes and pentenes.

[0021] When used with reference to feedstock-to-catalyst contact the term "short contact" indicates residence times in the range of 0.1 to 3 seconds. Residence times of less than 2 seconds or less than 1 second, in particular of less than even 0.5 s are possible.

Process Description

[0022] The process for catalytically converting hydrocarbons to light olefins comprises the conventional steps of feeding a hydrocarbon feedstock into a reaction zone containing a solid catalyst. In the reaction zone, the hydrocarbons

5 are contacted with the catalyst under conditions which favour catalytic conversion of hydrocarbons into light olefins. After the reaction, the light olefins produced and unreacted feedstock are separated from the catalyst particles. The spent, deactivated catalyst is recovered and regenerated in a regenerator by burning off the coke deposited on the catalyst particles.

[0023] According to the invention, the hydrocarbon feedstock is contacted with the catalyst in a circulating fluidized bed (CFB reactor), the residence time being in the range of 0.1 to 3 seconds. The CFB system according to the invention differs from the conventional FCC system in the respect that: 1) the vast volumetric reactor is replaced by a riser with a small external cyclone, and the reactions occur only in the riser pipe; 2) the bubbling bed regenerator is replaced by a CFB regenerator. Both of these improvements allow for enhanced residence time control and improved reactor construction.

10 [0024] To date, circulating fluidized bed reactors (CFBR) have primarily been used for noncatalytic processes. Known in the art is, however, also a circulating fluidized bed reactor (CFB) intended for maleic anhydride production based on catalytic oxidation of butane [Pugsley, T. et al., Ind. Eng. Chem. Res. 31 (1992), 2652-2660]. As a disadvantage of the known CFB construction, it should be mentioned that the catalyst volume fraction of the reactor cannot be freely controlled without affecting other process variables. Furthermore, there is no suggestion in the prior art that the same equipment could be used for cracking reactions or for the preparation of light olefins.

15 [0025] According to the invention, the spent catalyst is separated from the products and the hydrocarbon feedstock in an external cyclone connected to the CFB reactor. Preferably the regenerator comprises a similar piece of equipment as the reactor, so that the regeneration of the spent catalyst can be carried out in a second circulating fluidized bed. However, other types of regenerators can be used, as well.

20 [0026] According to the invention, it is possible to arrange two (or more) reactor units in series by using the product stream of the previous reactor as the feed of the following reactor. The reactors of this embodiment can be operated at different temperatures and pressures, which makes it possible to adapt the process to hydrocarbon feedstocks of most varying kind.

25 [0027] According to one particularly preferred embodiment, wherein the reactor system comprises a CFB reactor and a CFB regenerator, at least a part of the separated deactivated catalyst is conducted to the regenerator via a first pipe (the "spent catalyst pipe"), which is connected to the lower end of the regenerator. The feed of deactivated catalyst into the regenerator is preferably controlled by a valve connected to the feed nozzle of the pipe in such a way that there is at least a minimum amount of catalyst in the pipe in order to keep the pipe essentially gas tight. The "plug" formed by the catalyst in the pipe will prevent any gases emanating from the reaction zone from being conducted to the regenerator. This will eliminate the risk of explosions.

30 [0028] Within the scope of the invention, it is possible to conduct all of the separated deactivated catalyst to the regenerator, without any internal reactor recycle.

[0029] The deactivated catalyst is advantageously regenerated by combusting coke gathered on its surface in the second circulating fluidized bed at a temperature in the range of 650 to 800 °C preferably by introducing hot air and 35 optionally hot flue gas from additional fuel into the regenerator. As already mentioned above, it is also possible to use other types of regenerators, such as the conventional bubbling bed type regenerators.

40 [0030] An important advantage of the present reactor system, which will be described in more detail below, resides in the fact that the concentration of the catalyst in the reactor can be maintained at a high level, thus ensuring large catalytic surface contact with the hydrocarbon reactants. The reactor system according to the invention is, therefore, preferably equipped with a second pipe (the "catalyst recycle pipe"), for recycling of the catalyst separated by the cyclone back to the reactor.

45 [0031] The flow ratio of spent catalyst to be regenerated and recycled depends on the hydrocarbon feedstock, feed rate, catalyst used and the processing conditions.

50 [0032] As is the case with the CFB reactor, a part of the catalyst is preferably recycled back to the CFB regenerator via a recycle pipe, whereas the rest of the catalyst, i.e. the regenerator flows to the CFB reactor through the catalyst recycle pipe, which is connected to the bottom of the CFB reactor.

55 [0033] The invention can be used for converting hydrocarbons into light olefins under cracking as well as under dehydrogenation conditions. The hydrocarbon feedstock to be used for catalytic cracking in the present invention can consist of light gas oil (LGO), heavy gas oil (HGO), vacuum gas oil (VGO) or naphtha. Steam or another gas can be used as a diluent. The light olefins produced comprise ethylene, propylene, butylenes, amylenes, and a high octane, low benzene gasoline fraction. As solid catalysts, conventional (FCC) cracking catalysts and improved cracking catalysts are used. The catalyst types can be exemplified by natural and synthetic aluminium silicates, zeolites, clay etc. Conventional zeolites including X and Y zeolites, which may be stabilized with rare earth metals, are possible. The proc-

ess conditions for catalytic cracking in a reactor system according to the present invention are the following: reaction temperature: 520 to 700 °C; pressure: 105 to 500 kPa; residence time: 0.1 to 3 s, in particular 0.2 to 1 s. Residence times of less than 0.5 s (e.g. 0.2 - 0.49 s) are possible.

[0034] The invention can also be used for dehydrogenation of a hydrocarbon feedstock, such as propane, isobutane and light condensate to convert the feedstock to propylene, isobutylene and mixed butylenes, respectively. The reaction temperature is typically in the range of 580 to 750 °C. The same residence times as mentioned above can be used. Dehydrogenation catalysts known in the art, such as chromium/alumina, can be employed.

[0035] According to the invention air can be fed into the reactor in order to enhance the reaction, the amount of air feed being 0 to 50 %. If additional air is fed into the reactor, the amount thereof is preferably about 0.1 to about 50 %, in particular 10 - 40 %, calculated on the basis of the weight of the hydrocarbons.

[0036] The most important benefits of the invention, compared with the known processes are:

[0037] A short residence time and high catalyst volume fraction can be sustained without using complicated mechanical or pneumatic transport systems to carry catalyst from one unit to another.

[0038] All of the heat needed for the catalytic conversion of the hydrocarbon feedstock is being provided by the recycled catalyst regenerated in the circulating fluidized bed regenerator, except when air is also injected into the reactor and the resulting oxidation of the feedstock and the reaction products caused by air injection provides some heat into the reactor.

[0039] Catalyst volume fraction in the reactor can be set at desired value by internal catalyst recirculation, independently of other flows within the process.

[0040] The pressure levels of the reactor and the regenerator can be controlled independently from each other. This also gives a possibility to combine more than one reactor, operating with its own optimal process parameters and feedstock, with one common regenerator.

[0041] In comparison with the conventional cracking processes, the process of present invention provides high light olefin yield, good quality gasoline fraction, high conversion and simple, inexpensive reactor design.

[0042] In comparison with the current dehydrogenation processes, the present invention provides a very simple, inexpensive reactor/regenerator design.

[0043] In comparison with FCC type units, the regenerator is small and the catalyst loading is lower. This gives a possibility, with a proper design, to avoid current heavy refractory assemblies and use easy maintenance, lightweight, simple, inexpensive, externally insulated constructions.

[0044] The average cracking temperature across the CFB reactor can be increased without increasing the reactor inlet temperature and, as a result, the yield of light olefins is increased with the use of air as a prefluidization gas due to exothermic combustion taking place simultaneously with endothermic cracking in the reaction zone.

[0045] The attached drawing shows a preferred embodiment of the present invention. A short contact reactor/regenerator system is used to get desired process conditions. The basic principle governing the interaction of two CFB units is described in more detail in the Finnish Patent Application 924438 (Einco Oy, Finland).

[0046] According to the invention, a hydrocarbon feedstock mixed with heated catalyst is cracked in a short contact CFB reactor 1 at temperatures in the range of 520 to 700 °C. The hydrocarbons are fed through a feed nozzle (24). The operating pressure of the reactor is 105 to 500 kPa(a) and the residence time from 0.1 to 3 s, preferably from 0.2 to 2 s. The catalyst-to-oil ratio can vary from 1 to 120, preferably from 10 to 50. The partial pressure of hydrocarbon feed

can be decreased with the addition of steam or other diluent gases like recycle gas from the unit, but the use of diluent gas is not a prerequisite for the operation of the process. The feedstock enters from a pipe 17 and the prefluidization gas is injected through pipe 18.

[0047] After the cracking reaction, spent catalyst is separated from the products in a cyclone 2 located outside of the fluidized bed reactor. Hydrocarbons adsorbed in the spent catalyst will either remain in the spent catalyst and burn

in the regenerator 3 or can be stripped off in the stripping zone below the cyclone with steam 21, if stripping is economically justifiable. Products exit through the pipe 19. A part of the spent catalyst is transferred from the cyclone 2 to the regenerator 3 via the spent catalyst pipe 16, the flow of catalyst particles being regulated by a valve 8 on the pipe close to the feed nozzle 8' connected to the bottom of the regenerator 3. A part of the spent catalyst can be returned to the reactor as internal recycle via a control valve 6 on the catalyst recycle pipe 12. By controlling the catalyst recycle rate

with the valve 6, the catalyst volume fraction and temperature profile in the reactor can be adjusted. In order to prevent mixing of reactor and regenerator gases, the valve 8 controls the catalyst particle flow in such a manner that the pipe 16 is always filled with catalyst. The surface level control is indicated with an L.

[0048] The regenerator 3 is essentially a circulating fluidized bed reactor. The regenerator serves two purposes: Heat for the endothermic cracking reaction is supplied to the reactor by the catalyst heated in the regenerator and coke

deposited on spent catalyst particles is burned off. Regeneration of the catalyst takes place at temperatures in the range of 650 to 800 °C by blowing preheated air through an air inlet pipe 22 and injecting additional fuel through a pipe 23 to the lower end of the regenerator. Alternatively the additional fuel can be burned in a separate combustion chamber, from where the hot flue gases are led to the lower end of the regenerator through the pipe 22. Regenerated

hot catalyst is separated from combustion gases, which exit through outlet pipe 20 in the regenerator cyclone 4 and the regenerated catalyst is returned to the reactor 1 via a regenerated catalyst pipe 15, the flow being controlled by the control valve 9. The rest of the regenerated catalyst is returned as an internal recycle to regenerator via a catalyst recycle pipe 14.

- 5 [0049] At steady state conditions the catalyst flow rates through pipes 15 and 16 are equal. Catalyst is added to the system through the valve 5, which is controlled by the pressure difference between the top and bottom of the regenerator.  
 [0050] More than one reactor can be arranged in series with the hydrocarbon stream, or more than one reactor can be arranged in parallel, each having its own feed.  
 [0051] Products separated from the catalyst in the reactor cyclone can further be processed into intermediate product fractions using a standard or modified FCC process product recovery system.  
 10 [0052] As exemplifying embodiments of the present invention, the results of pilot plant tests on the conversion of gas oils to olefins are presented in the following.

#### Example 1

- 15 [0053] The system consisted of one CFB reactor and one CFB regenerator. The regenerated catalyst entering the reactor was prefluidized with nitrogen. Light gas oil (LGO) was fed through a nozzle with a small flow of distribution air in the reactor. No internal catalyst recycle was used in this test. The main parameters were the following:

20

Reactor:	
Height	1.85 m
Diameter	0.030 m
Oil mass flow rate	1.13 g/s
External catalyst/oil ratio	27 g/g
Internal catalyst/oil ratio	0 %
Catalyst volume fraction	2 to 7 %
Height of prefluidization pipe	0.25 m
Diameter of prefluidization pipe	0.018 m

35

40

Regenerator:	
Height	3.1 m
Diameter	0.08 m
Exit gas O <sub>2</sub> concentration	4 to 5 %
Catalyst volume fraction	4 %

45

#### Example 2

[0054] The reactor configuration and feedstock were the same as in example 1, with the exception that the internal and external catalyst/oil ratios were both about 15. The internal catalyst recycle inlet on the reactor was just above the oil injection point.

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#### Example 3

[0055] The reactor configuration and feedstock were the same as in example 2, except that no air was used for the

feed distribution and the internal catalyst recycle fraction was about 8.

**Example 4**

- 5 [0056] The reactor configuration and the feedstock were equal to those of example 1, except that air was used for  
prefluidization, but no feed distribution gas. Riser diameter in this run was 0.042 m.

Table 1

Results of the tests of Examples 1 to 4					
	Example 1	Example 2	Example 3	Example 4	
<b>Mass balance</b>					
Feed, g					
Oil	4,073	3,802	4,248	8,780	
Nitrogen	3,323	2,620	2,618	0	
Air	593	428	0	2,962	
Total	7,989	6,850	6,866	11,742	
Products, g					
Gas	5,593	4,563	4,406	7,164	
Condensate	2,132	1,594	2,234	3,555	
Coke	407	380	425	1,300	
Total	8,132	6,537	7,065	10,719	
Difference	-143	313	-199	-277	
Difference of feed	-2 %	5 %	-3 %	-2 %	
<b>Process</b>					
Yields, wt-%					
C <sub>1</sub> to C <sub>4</sub> alkanes	5.8	6.4	5.9	13.8	
C <sub>2</sub> <sup>a</sup> to C <sub>4</sub> <sup>a</sup>	26.2	24.2	21.2	26.0	
Gasoline	28.3	30.8	37.1	30.4	
Gas oil	23.9	23.1	20.3	12.5	
Bottoms	4.3	4.0	3.7	0.4	
Coke	10.7	9.9	11.5	14.3	
CO <sub>2</sub> , H <sub>2</sub> , H <sub>2</sub> O	0.8	0.8	0.2	2.5	
Total	100.0	99.8	99.7	99.9	
Conversion, wt-%					
Reactor temperature, °C	588	587	585	591	
Regenerator temp., °C	760	755	786	762	
Int. Catalyst/oil ratio	0	15	8	0	
Ext. Catalyst/oil ratio	27	15	15	22	
Residence time, s	0.25	0.31	0.32	0.83	

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**Claims**

1. A process for catalytically converting hydrocarbons to light olefins, comprising the steps of

- feeding a hydrocarbon feedstock into a reaction zone (1) containing a solid catalyst,
  - contacting the hydrocarbon feedstock in the reaction zone (1) with the catalyst under conditions which favour catalytic conversion of hydrocarbons into light olefins,
  - separating the reaction products obtained from the reaction zone (1) after catalytic conversion,
  - 5 - recovering the catalyst, and
  - regenerating the deactivated catalyst in a regenerator (3),  
characterized by
  - contacting the hydrocarbon feedstock with the catalyst in a circulating fluidized bed reactor (1) at a residence time in the range of 0.1 to 3 seconds,
  - 10 - withdrawing at least a part of the spent catalyst from the circulating fluidized bed reactor (1) and feeding it into a circulating fluidized bed regenerator (3) for regeneration by combustion,
  - recycling a part of the regenerated catalyst back to the regenerator (3), and
  - recycling the rest of the regenerated catalyst into the circulating fluidized bed reactor (1),
  - 15 whereby practically all of the heat needed for the catalytic conversion of the hydrocarbon feedstock is being provided by the recycled catalyst regenerated in the circulating fluidized bed regenerator (3).
2. A process according to claim 1, wherein all of the spent catalyst from the circulating fluidized bed reactor (1) is withdrawn and fed into the regenerator (3) for regeneration by combustion.
- 20 3. A process according to claims 1 or 2, wherein the spent catalyst is separated from the circulating fluidized bed reactor (1) in an external cyclone (2) connected to the reactor, at least a part of that catalyst is led to the regenerator (3) via a spent catalyst pipe (16), which is connected to the lower end of the circulating fluidized bed regenerator (3).
- 25 4. A process according to claim 3, wherein all of the separated catalyst is led to the regenerator (3).
5. A process according to claims 3 or 4, wherein the spent catalyst flow into the regenerator (3) via the spent catalyst pipe (16) is controlled by a valve (8) on the spent catalyst pipe (16) in such a way that the spent catalyst pipe (16) is at all times filled with catalyst in order to keep the reactor and the regenerator gases from mixing with each other.
- 30 6. A process according to any of claims 2 to 5, wherein the concentration in the reactor and the temperature profile across the reactor (1) is controlled by adjusting the catalyst recycle rate through a catalyst recycle pipe (12) to the reactor.
- 35 7. A process according to any one of the previous claims, wherein the regenerated catalyst is separated from the circulating fluidized bed regenerator (3) in a cyclone (4) external to the regenerator (3), a part of the catalyst is recycled to the circulating fluidized bed regenerator (3) via a catalyst recycle pipe (14), whereas the rest of the catalyst is led to lower end of the reactor (1) via a pipe (15) for regenerated catalyst.
- 40 8. A process according to claim 1, wherein a hydrocarbon feedstock such as light gas oil, heavy gas oil, vacuum gas oil or naphtha, is treated under catalytic cracking conditions with no diluent gas or using steam or other gas as a diluent to convert the hydrocarbon feedstock to light olefins such as propylene, butylenes, amylenes, and high octane, low benzene gasoline.
- 45 9. A process according to claim 8, wherein a solid catalyst is used which can be either conventional cracking catalyst or improved cracking catalyst.
10. A process according to any one of the previous claims, wherein the feedstock is contacted with the catalyst in the circulating fluidized bed reactor (1) at a temperature in the range of 520 to 700 °C, at a pressure of 105 to 500 kPa and with a residence time of 0.1 to 3.0 s.
- 50 11. A process according to claim 1, wherein a hydrocarbon feedstock, such as propane, isobutanes or light condensates, is treated under dehydrogenation conditions in the presence of a dehydrogenation catalyst in order to convert the hydrocarbon feedstock to propylene, butylenes or amylenes.
- 55 12. A process according to claim 11, wherein the feedstock is contacted with the catalyst in the circulating fluidized bed reactor (1) at a temperature in the range of 580 to 750 °C with a residence time of 0.1 to 3.0 s.

13. A process according to any one of the previous claims, wherein 0.1 to 50 % of air, calculated on the basis of the weight of the feedstock hydrocarbons, is fed into the reactor (1).
- 5      14. A process according to any one of the previous claims, wherein the deactivated catalyst is regenerated by combust-  
ing coke deposited on its surface in the circulating fluidized bed regenerator (3) at a temperature in the range of 650  
to 800 °C with hot air and optionally additional fuel.
- 15      15. A process according to claim 1, wherein the residence time is 0.2 to 2 seconds, preferably 0.2 to 1 seconds.
- 10      16. An apparatus for catalytically converting hydrocarbons to light olefins, comprising a combination of
- at least one circulating fluidized bed reactor (1),
  - nozzles (24) for feed of the hydrocarbon feedstock and the recycled catalyst (6') to the lower part of the circu-  
lating fluidized bed reactor (1),
  - a catalyst separation cyclone (2) on the outlet of the fluidized bed reactor (1) for separating the spent catalyst  
from the product stream of the reactor, said cyclone having a product outlet (19) and solids outlets (12, 16) for  
the catalyst,
  - one circulating fluidized bed unit regenerator (3) for catalyst regeneration, provided with a recycle pipe for recy-  
cling of a part of the regenerated catalyst back to the regenerator,
  - 20      - a nozzle (8') for the spent catalyst to be regenerated on the lower part of the second circulating fluidized bed  
regenerator (3), and
  - a catalyst separation cyclone (4) for separating the regenerated catalyst from the regenerator flue gases.
17. The apparatus according to claim 16, wherein the catalyst separation cyclone (2) on the outlet of the fluidized bed  
25      reactor (1) comprises an external cyclone connected to the reactor.
18. The apparatus according to claim 16, wherein the catalyst separation cyclone (4) for separating the regenerated  
catalyst from the regenerator flue gases comprises a cyclone external to the regenerator.

30      **Patentansprüche**

1. Verfahren zur katalytischen Umwandlung von Kohlenwasserstoffen in leichte Olefine, das die Schritte umfaßt:

  - Zuführen von Kohlenwasserstoff-Ausgangsmaterial in eine Reaktionszone (1), die einen festen Katalysator  
35      enthält,
  - In-Kontakt-bringen des Kohlenwasserstoff-Ausgangsmaterials in der Reaktionszone (1) mit dem Katalysator  
unter Bedingungen, die eine katalytische Umwandlung von Kohlenwasserstoffen in leichte Olefine begünstigen,
  - Abtrennen der aus der Reaktionszone (1) erhaltenen Reaktionsprodukte nach der katalytischen Umwandlung,
  - Zurückgewinnen des Katalysators, und
  - 40      - Regenerieren des deaktivierten Katalysators in einem Regenerator (3),  
gekennzeichnet durch
  - In-Kontakt-bringen des Kohlenwasserstoff-Ausgangsmaterials mit dem Katalysator in einem Reaktor (1) mit  
zirkulierender Wirbelschicht mit einer Verweilzeit im Bereich von 0,1 bis 3 Sekunden,
  - Entnehmen wenigstens eines Teils des verbrauchten Katalysators aus dem Reaktor (1) mit zirkulierender Wir-  
belschicht und Zuführen desselben in einen Regenerator (3) mit zirkulierender Wirbelschicht zur Regenerie-  
rung durch Verbrennung,
  - Rückführen eines Teils des regenerierten Katalysators zurück zu dem Regenerator (3), und
  - 45      - Rückführen des Restes des regenerierten Katalysators in den Reaktor (1) mit zirkulierender Wirbelschicht,  
wobei praktisch sämtliche Wärme, die für die katalytische Umwandlung des Kohlenwasserstoff-Ausgangsma-  
terials benötigt wird, durch den rückgeführten Katalysator, der in dem Regenerator (3) mit zirkulierender Wir-  
belschicht regeneriert wurde, geliefert wird.

2. Verfahren gemäß Anspruch 1, wobei der verbrauchte Katalysator vollständig dem Reaktor (1) mit zirkulierender  
Wirbelschicht entnommen und dem Regenerator (3) zur Regenerierung durch Verbrennung zugeführt wird.
- 55      3. Verfahren gemäß Anspruch 1 oder 2, wobei der verbrauchte Katalysator von dem Reaktor (1) mit zirkulierender  
Wirbelschicht in einem externen Zyklon (2), der mit dem Reaktor verbunden ist, abgetrennt wird, wobei wenigstens  
ein Teil des Katalysators zu dem Regenerator (3) über ein Rohr (16), welches mit dem unteren Ende des Regene-

ratoren (3) mit zirkulierender Wirbeischicht verbunden ist, für verbrauchten Katalysator geführt wird.

4. Verfahren gemäß Anspruch 3, wobei der abgetrennte Katalysator vollständig zu dem Regenerator (3) geleitet wird.
5. Verfahren gemäß Anspruch 3 oder 4, wobei der verbrauchte Katalysatorstrom in den Regenerator (3) über das Rohr (16) für verbrauchten Katalysator über ein Ventil (8) an dem Rohr (16) für verbrauchten Katalysator so geregelt wird, daß das Rohr (16) für verbrauchten Katalysator zu jedem Zeitpunkt mit Katalysator befüllt ist, um die Reaktor- und die Regeneratorgase davon abzuhalten, sich miteinander zu mischen.
10. 6. Verfahren gemäß irgendeinem der Ansprüche 2 bis 5, wobei die Konzentration in dem Reaktor und das Temperaturprofil über den Reaktor (1) durch Einstellen der Katalysatorrückführrate durch das Katalysatorrückführrohr(12) geregelt wird.
15. 7. Verfahren gemäß irgendeinem der vorherigen Ansprüche, wobei der regenerierte Katalysator aus dem Regenerator (3) mit zirkulierender Wirbeischicht in einem Zyklon (4), der extern zu dem Regenerator (3) ist, abgetrennt wird, wobei ein Teil des Katalysators zu dem Regenerator (3) mit zirkulierender Wirbeischicht über ein Rückführrohr (14) für Katalysator zurückgeführt wird, wobei der Rest des Katalysators zu dem unteren Ende des Reaktors (1) über ein Rohr (15) für regenerierten Katalysator geleitet wird.
20. 8. Verfahren gemäß Anspruch (1), wobei ein Kohlenwasserstoff-Ausgangsmaterial wie leichtes Gasöl, schweres Gasöl, Vakuumgasöl oder Naphtha unter katalytischen Crackbedingungen ohne Verdünnungsgas oder Verwenden von Dampf oder anderem Gas als Verdünnungsmittel behandelt wird, um das Kohlenwasserstoff-Ausgangsmaterial in leichte Olefine wie Propylen, Butylen, Amylen und hochoctaniges Benzin mit wenig Benzol umzuwandeln
25. 9. Verfahren gemäß Anspruch 8, wobei ein fester Katalysator verwendet wird, welcher entweder ein herkömmlicher Crack-Katalysator oder ein verbesserter Crack-Katalysator sein kann.
30. 10. Verfahren gemäß irgendeinem der vorherigen Ansprüche, wobei das Ausgangsmaterial mit dem Katalysator in dem Reaktor (1) mit zirkulierender Wirbeischicht bei einer Temperatur im Bereich von 520 bis 700°C, bei einem Druck von 105 bis 500 kPa und einer Verweilzeit von 0,1 bis 3,0 s in Kontakt gebracht wird.
35. 11. Verfahren gemäß Anspruch 1, wobei ein Kohlenwasserstoff-Ausgangsmaterial wie Propan, Isobutane oder leichte Kondensate unter Dehydrierungsbedingungen in Gegenwart eines Dehydrierungskatalysators behandelt wird, um das Kohlenwasserstoff-Ausgangsmaterial zu Propylen, Butylen oder Amylen umzuwandeln.
40. 12. Verfahren gemäß Anspruch 11, wobei das Ausgangsmaterial mit dem Katalysator in dem Reaktor (1) mit zirkulierender Wirbeischicht bei einer Temperatur im Bereich von 580 bis 750°C mit einer Verweilzeit von 0,1 bis 3,0 s in Kontakt gebracht wird.
45. 13. Verfahren gemäß irgendeinem der vorherigen Ansprüche, wobei 0,1 bis 50 % Luft, berechnet auf Basis des Gewichts der Ausgangsmaterial-Kohlenwasserstoffe, dem Reaktor (1) zugeführt wird.
14. Verfahren gemäß irgendeinem der vorherigen Ansprüche, wobei der deaktivierte Katalysator durch Verbrennen von Koks, der auf dessen Oberfläche abgelagert ist, in dem Regenerator (3) mit zirkulierender Wirbeischicht bei einer Temperatur im Bereich von 650 bis 800°C mit heißer Luft und wahlweise zusätzlichem Brennstoff regeneriert wird.
50. 15. Verfahren gemäß Anspruch 1, wobei die Verweilzeit 0,2 bis 2 Sekunden, bevorzugt 0,2 bis 1 Sekunde(n), beträgt.
16. Vorrichtung zur katalytischen Umwandlung von Kohlenwasserstoffen in leichte Olefine, die umfaßt eine Kombination aus
  - wenigstens einem Reaktor (1) mit zirkulierender Wirbeischicht,
  - Düsen (24) zum Zuführen des Kohlenwasserstoff-Ausgangsmaterials und des zurückgeführten Katalysators (6) zu dem unteren Bereich des Reaktors (1) mit zirkulierender Wirbeischicht,
  - einem Katalysator-Abscheidezyklon am Auslaß des Wirbeeschichtreaktors (1) zum Abtrennen des verbrauchten Katalysators von dem Produktstrom des Reaktors, wobei der Zyklon einen Produktauslaß (19) und Feststoffauslässe (12, 16) für den Katalysator aufweist,

- eine Regeneratoreinheit (3) mit zirkulierender Wirbelschicht zur Katalysatorregenerierung, die mit einem Rückführrohr zum Rückführen eines Teils des regenerierten Katalysators zurück zu dem Regenerator ausgestattet ist,
- eine Düse (8) für den verbrauchten Katalysator, der im unteren Bereich des zweiten Regenerators (3) mit zirkulierender Wirbelschicht regeneriert werden soll, und
- einen Katalysator-Abscheidezyklon (4) zum Abtrennen von regeneriertem Katalysator von den Brenngasen des Regenerators.

5            17. Vorrichtung gemäß Anspruch 16, wobei der Katalysator-Abscheidezyklon (2) am Auslaß des Wirbelschichtreaktors  
 10          (1) einen externen Zyklon, der mit dem Reaktor verbunden ist, umfaßt.

15          18. Vorrichtung gemäß Anspruch 16, wobei der Katalysator-Abscheidezyklon (4) zum Abtrennen des regenerierten Katalysators von den Abgasen des Regenerators einen Zyklon, der extern zu der Regenerator ist, umfaßt.

## 15 Revendications

1. Procédé pour la conversion catalytique d'hydrocarbures en oléfines légères, comprenant les étapes

- d'introduction d'un mélange d'hydrocarbures de départ dans une zone réactionnelle (1) contenant un catalyseur solide,
- de mise en contact du mélange d'hydrocarbures dans la zone réactionnelle (1) avec le catalyseur dans des conditions favorisant la conversion catalytique des hydrocarbures en oléfines légères,
- de séparation des produits de la réaction obtenus dans la zone réactionnelle (1) après la conversion catalytique,
- de récupération du catalyseur, et
- de régénération du catalyseur désactivé dans un régénérateur (3), caractérisé par
- la mise en contact du mélange d'hydrocarbures de départ avec le catalyseur dans un réacteur (1) à lit fluidisé circulant, avec un temps de séjour compris entre 0,1 et 3 secondes,
- le soutirage d'au moins une partie du catalyseur épuisé à partir du réacteur (1) à lit fluidisé circulant et par son introduction dans un régénérateur (3) à lit fluidisé circulant en vue de la régénération par combustion,
- le recyclage d'une partie du catalyseur régénéré par renvoi dans le régénérateur (3), et
- le recyclage du reste du catalyseur régénéré dans le réacteur (1) à lit fluidisé circulant, grâce à quoi pratiquement toute la chaleur nécessaire pour la conversion catalytique du mélange d'hydrocarbures de départ est fournie par le catalyseur recyclé régénéré dans le régénérateur (3) à lit fluidisé circulant.

20          2. Procédé selon la revendication 1, dans lequel tout le catalyseur épuisé provenant du réacteur (1) à lit fluidisé circulant est soutiré et introduit dans le régénérateur (3) en vue de la régénération par combustion.

25          3. Procédé selon la revendication 1 ou la revendication 2, dans lequel le catalyseur épuisé est séparé depuis le réacteur (1) à lit fluidisé circulant, dans un cyclone externe (2) relié audit réacteur, au moins une partie du catalyseur est dirigée vers le régénérateur (3) à travers une conduite (16) destinée au catalyseur épuisé et qui est reliée à l'extrémité inférieure du régénérateur (3) à lit fluidisé circulant.

30          4. Procédé selon la revendication 3, dans lequel tout le catalyseur séparé est dirigé vers le régénérateur (3).

35          5. Procédé selon la revendication 3 ou la revendication 4, dans lequel le flux de catalyseur épuisé entrant dans le régénérateur (3) à travers la conduite (16) de catalyseur épuisé, est contrôlé par une vanne (8) placée sur ladite conduite (16) de catalyseur épuisé, de façon à ce que ladite conduite (16) de catalyseur épuisé soit à tout moment remplie de catalyseur afin d'empêcher le mélange mutuel des gaz du réacteur et des gaz du régénérateur.

40          6. Procédé selon l'une quelconque des revendications 2 à 5, dans lequel la concentration dans le réacteur et le profil de température à travers le réacteur (1) sont contrôlés par l'ajustage de la vitesse de recyclage du catalyseur à travers la conduite (12) de recyclage du catalyseur vers le réacteur.

45          7. Procédé selon l'une quelconque des revendications précédentes, dans lequel le catalyseur régénéré est séparé du régénérateur (3) à lit fluidisé circulant, dans un cyclone (4) extérieur audit régénérateur (3), une partie du catalyseur est recyclée dans le régénérateur (3) à lit fluidisé circulant à travers une conduite (14) de recyclage de cata-

lyseur, alors que le reste du catalyseur est dirigé vers l'extrémité inférieure du réacteur (1) à travers une conduite (15) destinée au catalyseur régénéré.

8. Procédé selon la revendication 1, dans lequel un mélange d'hydrocarbures de départ tel que l'huile légère de pétrole, l'huile lourde de pétrole, l'huile de pétrole volatile ou naphta, est traité dans des conditions de craquage catalytique sans gaz diluant ou en utilisant la vapeur ou un autre gaz en tant que diluant pour convertir ledit mélange d'hydrocarbures de départ en oléfines légères telles que le propylène, les butylènes, les amylènes et le carburant à haut indice d'octane et faible indice de benzène.
10. Procédé selon la revendication 8, dans lequel on utilise un catalyseur solide qui peut être soit un catalyseur de craquage conventionnel, soit un catalyseur de craquage amélioré.
15. Procédé selon l'une quelconque des revendications précédentes, dans lequel le mélange de départ est mis en contact avec le catalyseur dans le réacteur (1) à lit fluidisé circulant à une température comprise entre 520 et 700°C, à une pression de 105 à 500 kPa et avec un temps de séjour de 0,1 à 3,0 secondes.
20. Procédé selon la revendication 1, dans lequel un mélange d'hydrocarbures de départ tels que le propane, les iso-butanes ou les condensats légers est traité dans des conditions de déshydrogénération en présence d'un catalyseur de déshydrogénération afin de convertir ledit mélange d'hydrocarbures de départ en propylène, en butylènes ou en amylènes.
25. Procédé selon la revendication 11, dans lequel le mélange de départ est mis en contact avec le catalyseur dans le réacteur (1) à lit fluidisé circulant, à une température comprise entre 580 et 750°C avec un temps de séjour de 0,1 à 3,0 secondes.
30. Procédé selon l'une quelconque des revendications précédentes, dans lequel une proportion de 0,1 à 50 % de l'air, calculée par rapport au poids du mélange d'hydrocarbures de départ, est introduite dans le réacteur (1).
35. Procédé selon l'une quelconque des revendications précédentes, dans lequel le catalyseur désactivé est régénéré par la combustion du coke déposé sur sa surface dans le régénérateur (3), à une température comprise entre 650 et 800°C, avec de l'air chaud et éventuellement du combustible additionnel.
40. Procédé selon la revendication 1, dans lequel le temps de séjour est compris entre 0,2 et 2 secondes, de préférence entre 0,2 et 1 seconde.
45. Appareil destiné à la conversion catalytique d'hydrocarbures en oléfines légères, comprenant une association
  - d'au moins un réacteur (1) à lit fluidisé circulant,
  - de buses (24) destinées à l'introduction du mélange d'hydrocarbures de départ et du catalyseur recyclé (6') dans la partie inférieure du réacteur (1) à lit fluidisé circulant,
  - d'un cyclone (2) de séparation du catalyseur, à la sortie du réacteur (1) à lit fluidisé circulant, destiné à la séparation du catalyseur épousé provenant du courant de produits du réacteur, ledit cyclone comportant une sortie (19) pour les produits et des sorties (12, 16) pour le catalyseur,
  - d'une unité régénératrice (3) à lit fluidisé circulant destinée à la régénération du catalyseur, pourvue d'une conduite de recyclage destinée au recyclage par renvoi dans le régénérateur, d'une partie du catalyseur régénéré,
  - d'une buse (8) destinée au catalyseur épousé à régénérer, placée sur la partie inférieure du second réacteur (3) à lit fluidisé circulant, et
  - d'un cyclone (4) destiné à la séparation du catalyseur à partir des gaz sortant par la conduite provenant du régénérateur.
50. Appareil selon la revendication 16, dans lequel le cyclone (16) de séparation du catalyseur, placé à la sortie de réacteur (1) à lit fluidisé circulant, comprend un cyclone externe relié au réacteur.
55. Appareil selon la revendication 16, dans lequel le cyclone (4) de séparation du catalyseur destiné à séparer le catalyseur régénéré, à partir des gaz sortant par la conduite provenant du régénérateur, comprend un cyclone extérieur audit régénérateur.



